

Work Order ID 70616

Monday, June 13, 2011 12:34:31 PM



Page 1

Item ID: D3302-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

H

Date:

6-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3302	Rev B2

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3302 ☐ Dwg Rev: B2 ☐ Prog Rev: B2 ☐ 2-
Deburr if necessary

6061.063

B11-6-23

(C)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-23

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/123

(H6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr break all unmarked sharp edges 0.005 to 0.010

N/A

140



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Form as per Dwg D3302

SP 11606/29

(6)

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

SP 11606/29

(6)

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>6</u>		<u>BK 11.8.4.</u>	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<u>6X of M-L 11/07/04</u>
180 Packaging Packaging	Identify as per dwg & Stock Location: <u>143</u> Memo	0.00 0.00						<u>11/7/4</u>	<u>625</u>

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/4
CZ11/07/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 12:34:39 PM

Page 1

Work Order ID: 70616

Parent Item: D3302-3

Parent Item Name: Doubler



Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP ☐ A ☐ 04.09.02 ☐ New issue ☐ KJ/JLM ☐
IPP ☐ B ☐ 06.05.02 ☐ Water jet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063		Purchased	No			100	sf	285.0000	0.9931	6.272211			
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6061-T6 .063 Sheet



B11-6-23

Location

Loc Qty

Loc Code

MAT021

285

116308

29

117285

256

17285

(6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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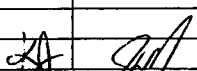
DART AEROSPACE LTD		Work Order:	70616
Description: Doubler		Part Number:	D3302-3
Inspection Dwg: D3302 Rev: B2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.452	+/-0.010	14.452	✓		T	
12.75	+/-0.030	12.75	✓		T	
0.851	+/-0.010	.853	✓		V	
0.851	+/-0.010	.851	✓		V	
8.952	+/-0.010	8.959	✓		V	
R0.12	+/-0.030	.12			R.G	
7.250	+/-0.010	7.246	✓		V	

Measured by: TB	Audited by: S	Prototype Approval:	N/A
Date: 11-6-23	Date: 11/04/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev update; Dimensions revised to revision B2	KJ/JLM	
C	07.01.16	Dimensions revised	KJ/JLM	
D	07.01.29	Dimensions revised	KJ/JLM	

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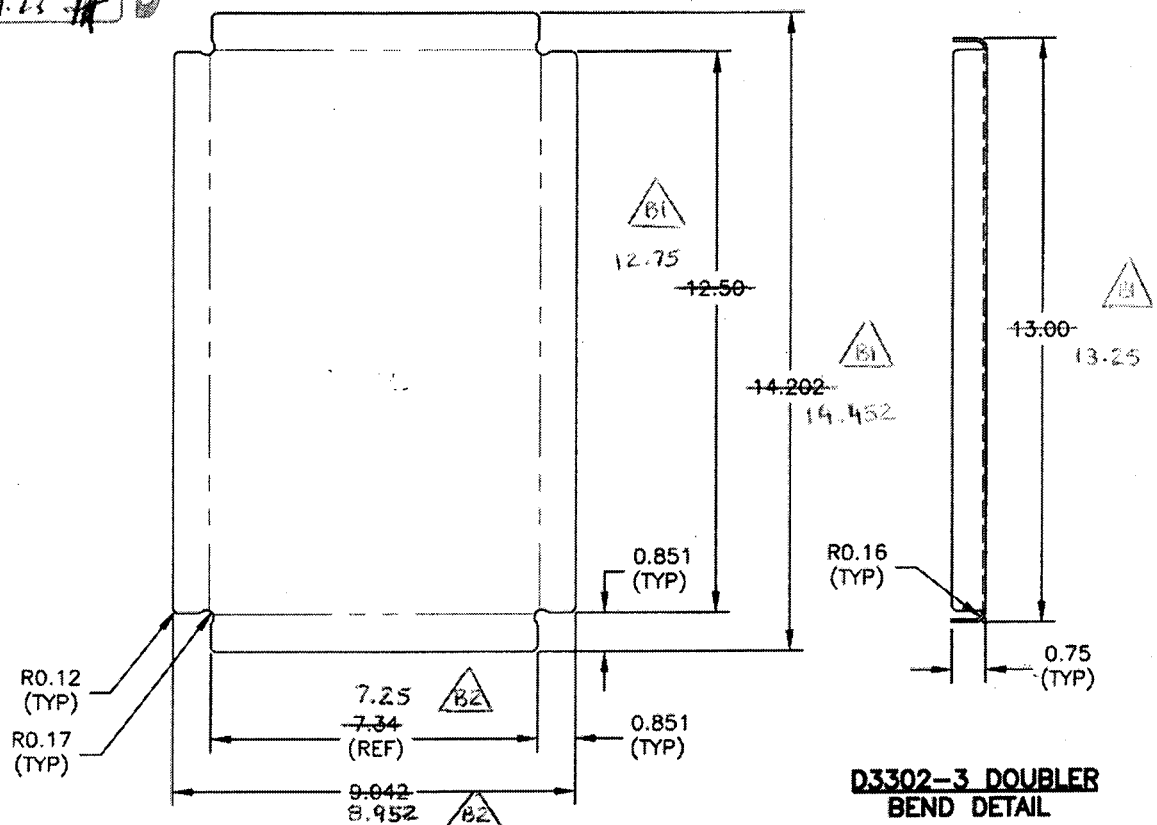
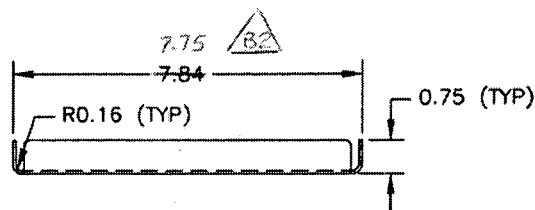
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DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.23 #**D3302-3 FLAT PATTERN****D3302-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70616

pl 11-06-17

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